

Date: Tuesday, 07/04/2009 10:20:35 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ACCESS PANEL ASSEMBLY
<b>Job Number</b> : 46974	
<b>Estimate Number</b> : 12949	
<b>P.O. Number</b> :	<b>Part Number</b> : D3259042
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3249 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 44236	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/04/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.04.07</u>	
<b>Comment</b> : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick Assembly Kit

2.0	D32591	Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 panel  
 Batch: B477188

3.0	D32594	Doubler
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Doubler  
 Batch: 44303 x 5

4.0	D32595	Spacer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Spacer  
 Batch: B43774 x 4

5.0	D32597	Door
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Door  
 Batch: B477192

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:20:35 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 46974

Part Number: D3259042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D31615	Hinge 9.9"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 9.9"

Batch: ~~B413600~~ ~~B 7157 340~~ *M101334* *P 9/5/5* *SS 09/04/15 (x6)*

7.0	D32601	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spring

Batch: *B 7193* *P 9/5/5*

8.0	127H5	HALF GROMMET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

HALF GROMMET

Batch: *M 111451* *SS 09/04/15 (x6)*

9.0	250018C3Y	RIGHT RECEPTACLE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

RIGHT RECEPTACLE

Batch: *M105932* *SS 09/04/15 (x6)*

10.0	2501W20020C3Y	STUD
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

STUD

Batch: *M110118* *SS 09/04/15 (x6)*

11.0	MS20426AD44	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet

Batch: *M15541* *SS 09/04/15 (x6)*

12.0	MS20470AD34	Rivet, Universal Head
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Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Rivet, Universal Head

Batch: *M15541* *SS 09/04/15 (x6)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/05/07	6	change D3161-5 for MS 20257-3-7200 Batch <u>M101334</u> cut rings at 9.9" Permanent chg Done <u>E</u> 09-05-07	<u>CP</u>	09/05/07	6	<u>E</u> 09-05-07	<u>/</u> 090507	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:20:35 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 46974

Part Number: D3259042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS20470AD35	Rivet
------	-------------	-------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)

Rivet

Batch:

M9682

SS 09/04/15 (x6)

14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259.

Note:Keep .040" Gap all around door.

EP 09/05/07 (6)

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/05/08 (x6)

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

184

958

(1A)

SP

17.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/05/11

Job Completion



MF 09-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

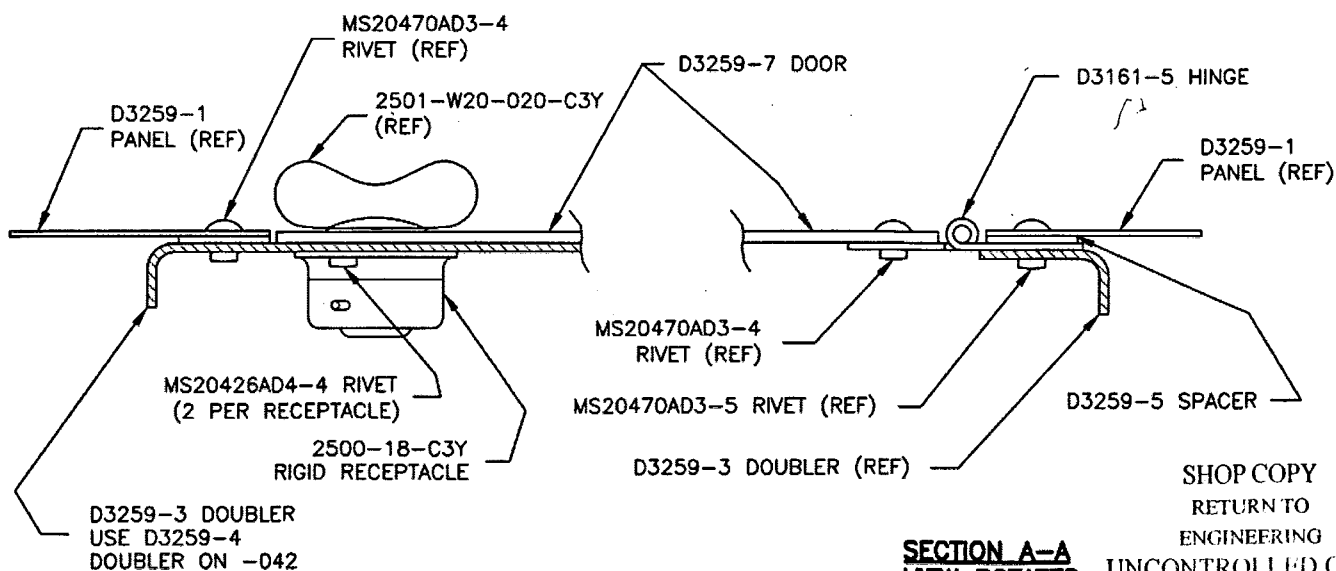
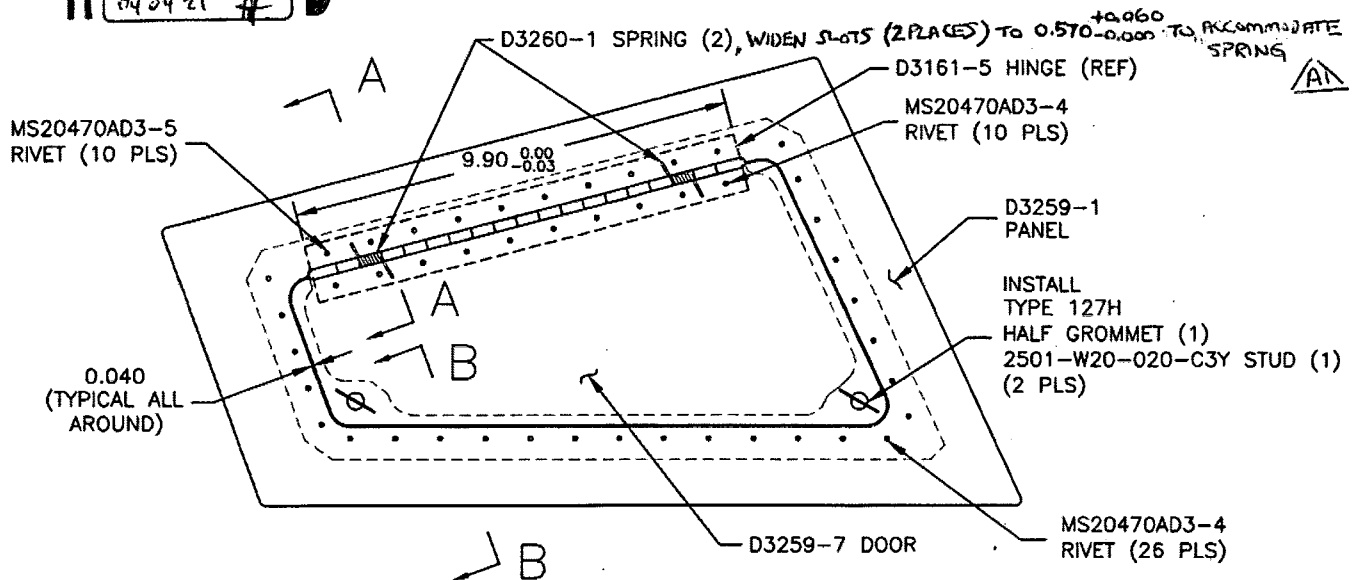
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD
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CHECKED	#	APPROVED	#	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	CP # 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED  
174 04 21 #



SECTION B-B  
VIEW ROTATED

SECTION A-A  
VIEW ROTATED

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NO. 16974

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)  
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

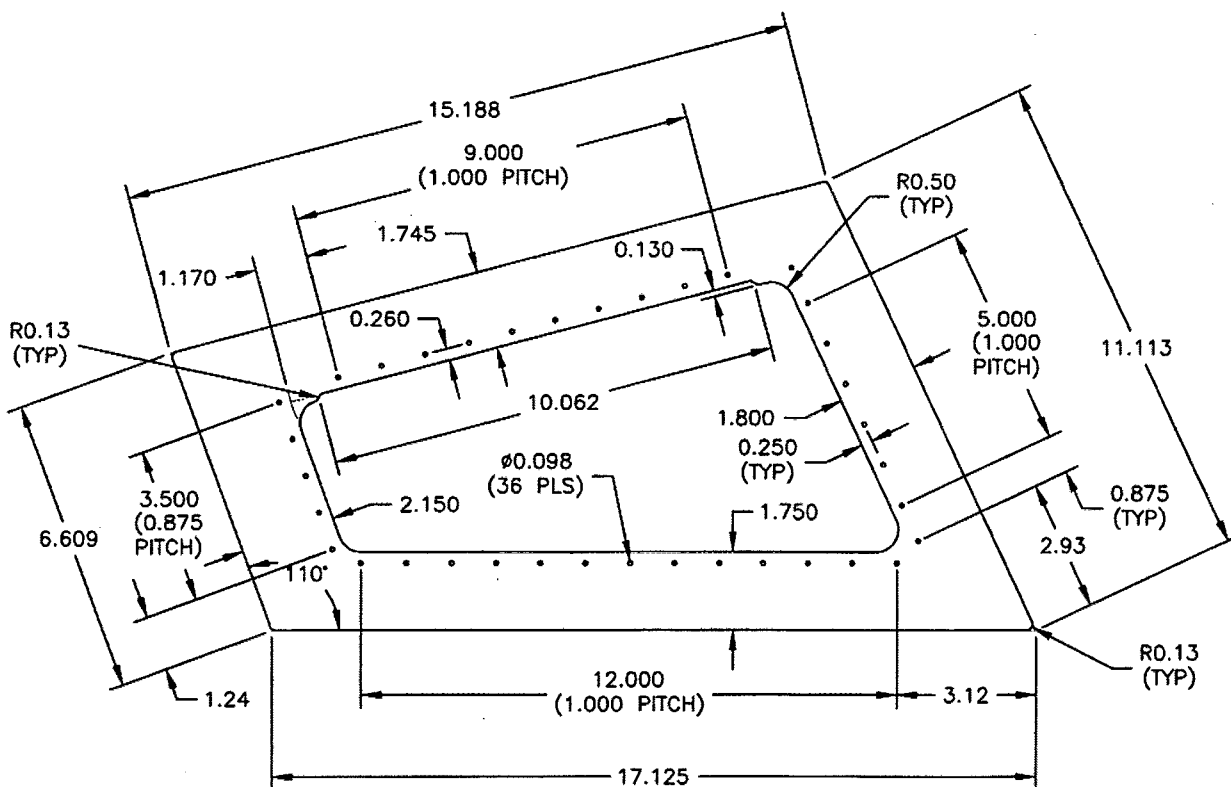
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05



### D3259-1 PANEL

#### NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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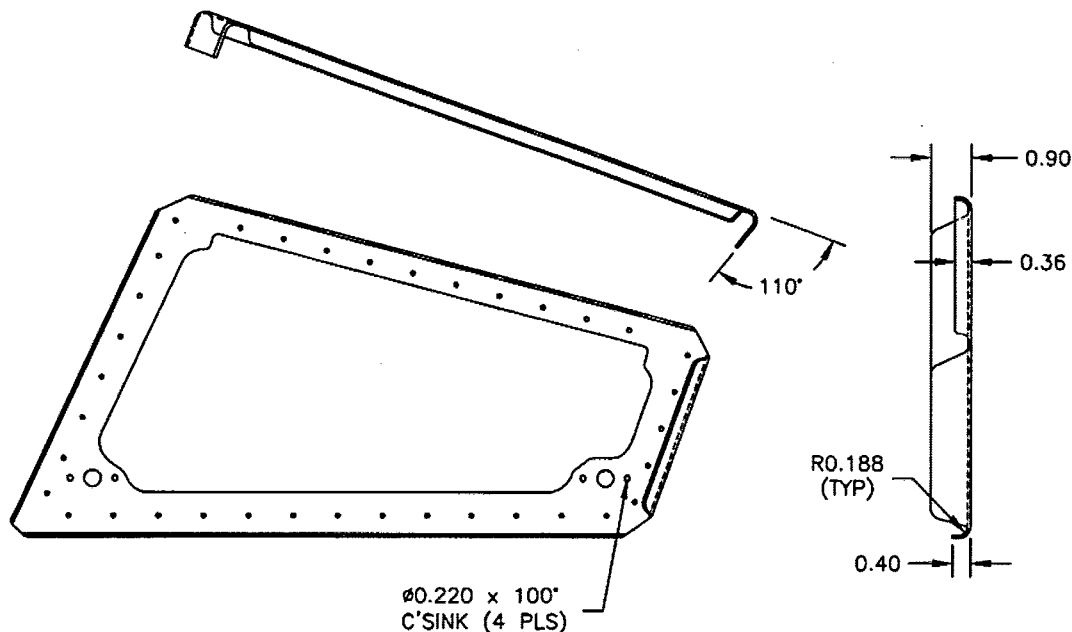
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.14



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**  
BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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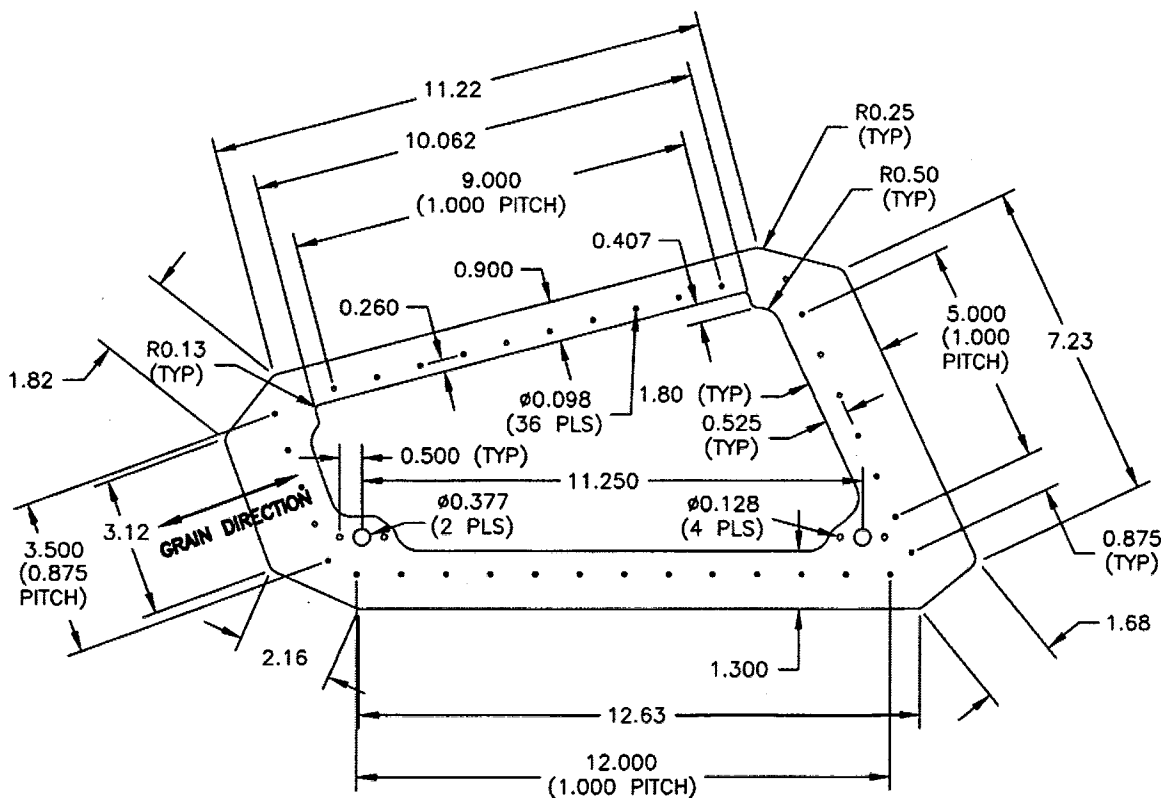
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04 04 14



**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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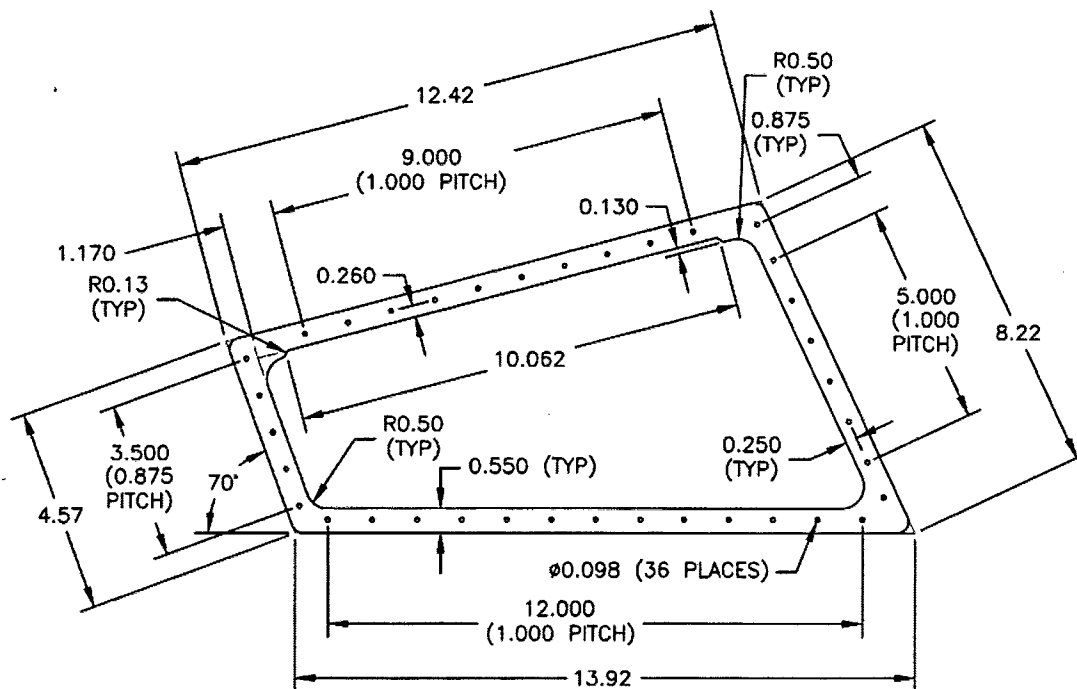
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RELEASED  
04.02.05



### D3259-5 SPACER

( $\phi$ 0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

#### NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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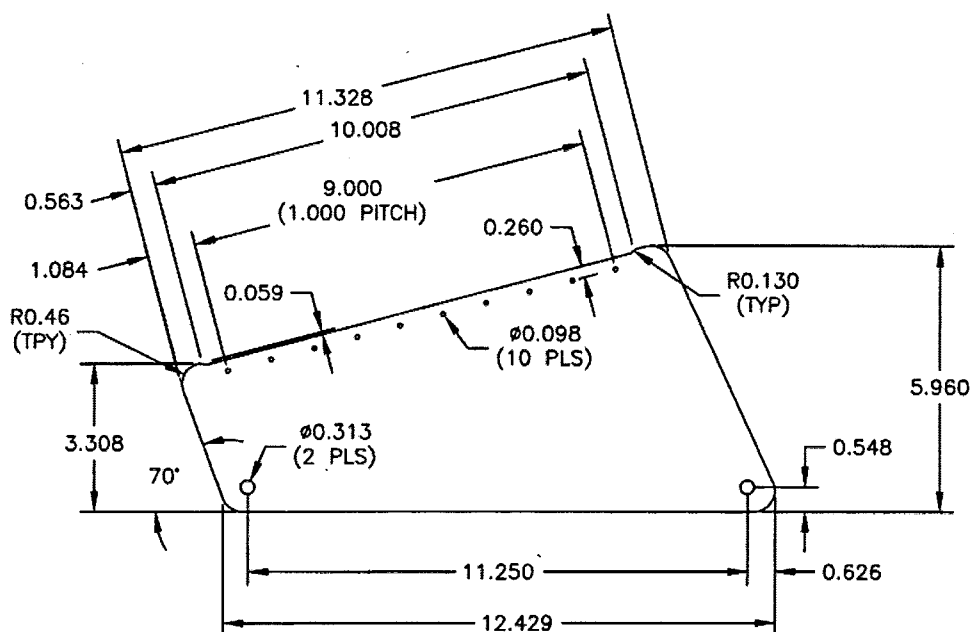
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.14



**D3259-7 DOOR**

**NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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